

W/SET



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBBP1425-105-03
Job Sheet 176791



Part No: RBBP1425-105-03

Job Qty: 8 ea

Part Name: Keeper



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/1/18

Job Tracking No:

Due Date: 8/27/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP
Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/27/18	8/27/18	0.00	0.00	Start Up Machining-3		OK 18/08/23
100	Waterjet	8 pcs	8/27/18	8/27/18	0.00	0.80	Waterjet 2 OMAX		OK 18/08/23
110	Mori Seiki	8 pcs	8/27/18	8/27/18	0.00	4.00	MORI SL2500Y		OK
120	QC	8 pcs	8/27/18	8/27/18	0.00	0.00	QC2 Machining-4		OK
130	Mori Seiki	8 pcs	8/27/18	8/27/18	0.00	2.00	MORI NV5000-1		OK 18-11-24
140	QC	8 pcs	8/27/18	8/27/18	0.00	0.00	QC2 Machining-4		OK 18-11-24
150	QC	8 pcs	8/27/18	8/27/18	0.00	0.00	QC8 Machining-4		OK 18-11-24
180	Outsource	8 pcs	8/27/18	8/27/18	0.00	0.00	Outsource12		OK 18-11-24
200	Packaging	8 pcs	8/27/18	8/27/18	0.00	0.00	Packaging2		DEC 05 2018
210	QC	8 pcs	8/27/18	8/27/18	0.00	0.00	QC6		OK 18-11-24
215	Packaging	8 pcs	8/27/18	8/27/18	0.00	0.00	Packaging3-1		OK 18-11-24
220	QC21-SA	8 Ea	8/27/18	8/27/18	0.00	0.00	QC21		OK 18-11-24

Part Op 100 - Cut blanks (RED BARN FOLDER) ***Note***makes four pieces***
 Descriptions: 110 - 1-Machine as per folio FC026 FOLIO REV: _____ DWG REV: _____ 2-Deburr
 130 - 1-Machine as per folio FC026 FOLIO REV: _____ DWG REV: _____ ***Note***makes four
 pieces*** 2-Deburr 3-Machine engrave as per note 6
 180 - -Issue P/O to Groupe Altech; PO 41370 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
 Conformity is required

9-89 DEC 06 2018

DAS
13
9-89

NOV 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500X10.000	AlSi 4140 Steel Sheet/Plate	4.3200 ft (.54 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-0.500X10.000	4	11	0

Part Specifications

Specifications could not be found.

Plex 8/22/18 12:59 PM dart.logan.david



Container No: S104483



Part: RBBP1425-105-03

Job No: 176791

Serial No/Batch: S104483

Revision: D

Inspector:

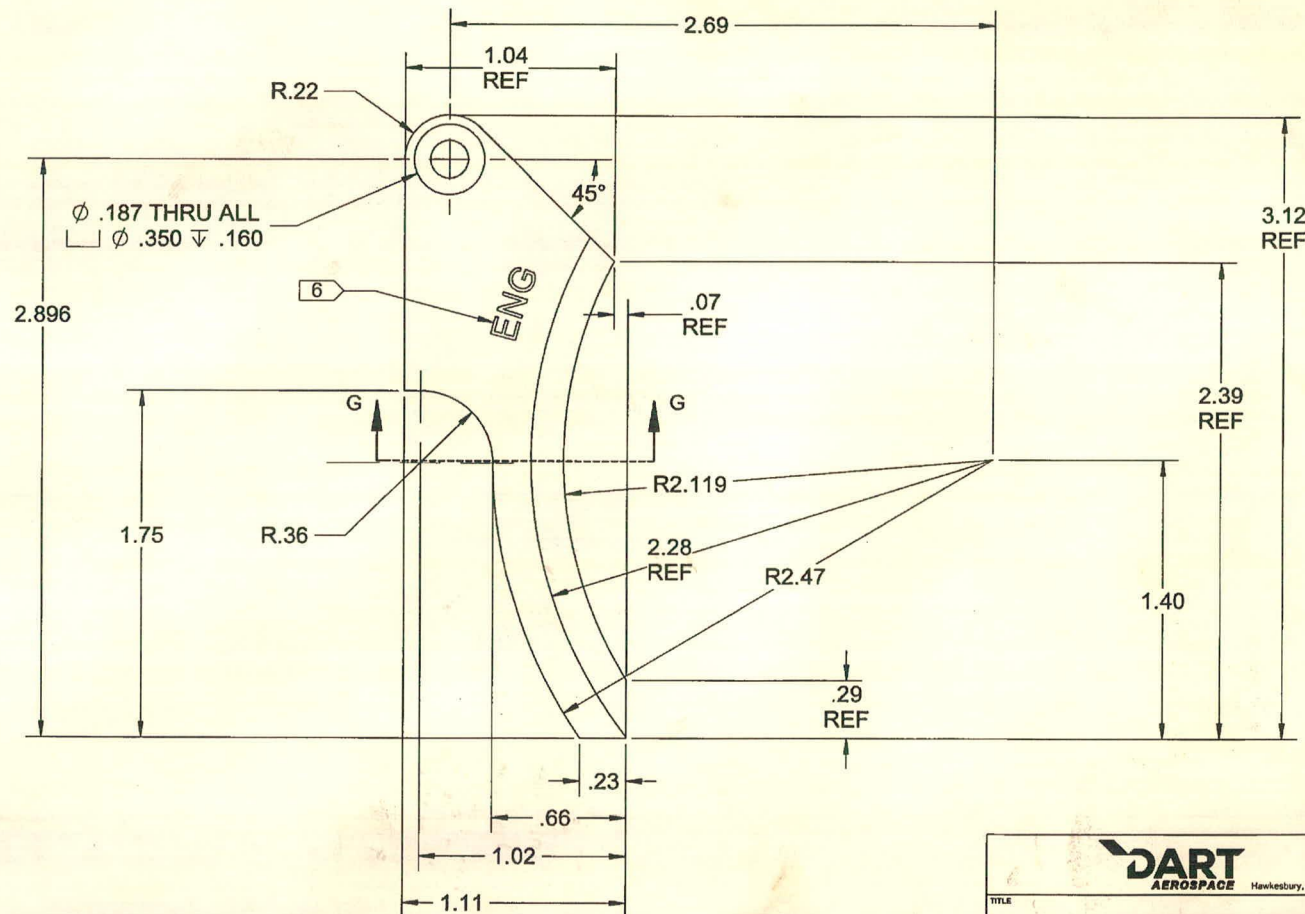
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/23/16

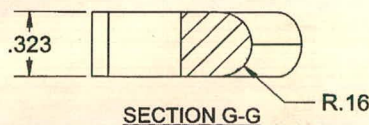
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	TEMPLATE UPDATED, MATERIAL 4140/4142 CHANGED FOR 17-4 PH / H900, FINISH REMOVED, VIEWS CHANGED FOR CLARITY, NOTE 7 ADDED	17-847	18.1.3	VM	ML



RBBP1425-105-03 KEEPER

NOTES:

- 1) MATERIAL: 17-4 PH SS / H900 OR 4140/4142 (Rc 28-32)
- 2) FINISH: IF MANUFACTURED FROM 17-4PH-H900: N/A
IF MANUFACTURED FROM 4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN AND FILL WITH BLACK INK, 0.010" DEPTH
- 7) REFER TO CAD MODEL FOR ALL NON DIMENSIONED FEATURES



DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE KEEPER			
PART NO. RBBP1425-105-03		REV D	
TOOL NO. RBBP1425-105			
INITIALS AND DATE		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY:	VM 1/23/2018	TOLERANCES:	FRACTIONS ± 1/8
DRAWN BY:	ML 03/20/2018	XXX ± .005	ANGLES ± .5°
CHECKED BY:	ML 03/20/2018	XX ± .01	SURFACE
MFG REVIEW BY:	DP 03/20/2018	X ± .1	ROUGHNESS
APPROVED BY:	ML 03/26/2018	SCALE: NTS	SHEET 11 OF 12
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041870**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041870
PO Date: 11/28/18
Due Date: 12/4/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178487	RBT18560-9	Cross Bar -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	12/4/18	8 pcs	0 pcs	8 pcs	\$3.5294117/pcs	\$28.24
							8 x DEC 05 2018				
2	175857	RBBP1425-105-03	Keeper -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	12/4/18	12 pcs	0 pcs	12 pcs	\$3.5294117/pcs	\$42.35
							12 x DEC 05 2018				
	176791			Firmed	-	12/5/18	12 pcs	0 pcs	12 pcs	\$3.5294117/pcs	\$42.35
							12 x DEC 05 2018				
Sub Total:							24	0	24		\$84.71

DAS
38
9-89

3	186297	RB6872879-1	Socket Head Cap Screw -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	12/4/18	2 pcs	0 pcs	2 pcs	\$3.5294117/pcs	\$7.06
							2 x DEC 05 2018				



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PURCHASE ORDER

PO041870

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/3/18 8:08 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014859- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
04-Dec-2018		Ross Montieth				041870			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Orde
1	RBT18560-9 Rev. ✓	RBT18560-9 BLACK OXIDE FINISH MIL-C-13924C CLASS 1		OXIDE-BLACK CH	8	8	0	0	0
2	RBBP1425-105-03 Rev. ✓	RBBP1425-105-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	12	12	0	0	0
3	RBBP1425-105-03 Rev. ✓	RBBP1425-105-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	12	12	0	0	0
4	RB6872879-1 Rev. ✓	RB6872879-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS		BLACK-OXIDE CH	2	2	0	0	0

DAS
38
9-89

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

